

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010962**Date Inspected:** 31-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**BAY 2****Green Tags**

The following green tags issued for the OBG components after completing the NDT requirements are:

1. FB3007 – 002 – Green Tag # 11267
2. FB3073 – 002 – Green Tag # 11281
3. FB3069 – 002 – Green Tag # 11276

This QA Inspector observed the following work in progress:

**Flux Core Arc Welding (FCAW):**

Weld joint # 008 located on Longitudinal Diaphragm LD3019 – 001. Welder is identified as 045240. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 022 located on Longitudinal Diaphragm LD3020 – 001. Welder is identified as 062708. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to

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comply with the WPS – B – T – 2132 – 3.

Weld joint # 013 located on Longitudinal Diaphragm LD3019 – 001. Welder is identified as 045209. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

### BAY 3

This QA Inspector observed the following work in progress:

#### Flux Core Arc Welding (FCAW):

Weld joint # 033 located on Corner Assembly CA3003C. Welder is identified as 208035. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 173 located on Corner Assembly CA3005C. Welder is identified as 208035. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

#### Shielded Metal Arc Welding (SMAW):

Weld joint # 181 located on Cross Beam CB202G – 041. Welder is identified as 051359. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113 – FCM – 1.

Weld joint # 180 located on Cross Beam CB202G – 044. Welder is identified as 058102. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113 – FCM – 1.

### BAY 5

This QA Inspector observed the following work in progress:

#### Flux Core Arc Welding (FCAW):

Weld joint # 007 located on Traveler Rail 11TR1 – 010. Welder is identified as 217185. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 014 located on Traveler Rail 11TR3 – 007. Welder is identified as 067275. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 005 located on Traveler Rail 11TR3 – 017. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

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Weld joint # 006 located on Traveler Rail 11TR1 – 007. Welder is identified as 250353. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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